

WORK INSTRUCTION		
Title: Repair of Inner Containment Vessel (ICV)/Outer Containment Vessel (OCV) Locking Ring Stop Plate(s)		
Instruction No. CH.16	Rev. 0.1, November 2002	Page 1 of 3
Approved for Use by: <u>Michael R. Brown</u> Effective Date: <u>November 2002</u>		
Applicable Drawings: <ul style="list-style-type: none"> • 2077-500SNP (Sheet 8) - TRUPACT-II Packaging Safety Analysis Report for Packaging (SARP) Drawings • 707-SAR (Sheet 10) - HalfPACT Packaging SARP Drawings 		
SARP Requirements: <ul style="list-style-type: none"> • None 		
Tools Required: <ul style="list-style-type: none"> • Small grinder • Welder (TIG preferred) 		
Spare Parts Required: <ul style="list-style-type: none"> • None 		
Materials Required: <ul style="list-style-type: none"> • 304 stainless steel, 12 gauge (w/Certified Material Test Report) • Weld filler material per approved weld procedure (w/cmtr) 		
Safety Requirements: <ul style="list-style-type: none"> • Safety will be observed in accordance with site requirements. 		
Prerequisite Conditions: <ul style="list-style-type: none"> • ICV/OCA lid(s) must be removed. • Welder must be qualified in accordance with Section IX of American Society of Mechanical Engineers (ASME) Code for the process being used. • Weld procedures and inspection procedures must have been approved by the Management and Operating Contractor. • Preferred weld method is gas tungsten arc welding for A-240 stainless steel. 		
Instruction Steps: <ul style="list-style-type: none"> • All steps in this procedure must be documented on the Data Sheet (Attachment 1) or on an attached approved manufacturing traveler to the data sheet. • This instruction is not required to be attached to the Maintenance Record, but may be used as a checklist during performance of maintenance. • Attachment 1 shall be completed for each locking ring stop repaired/replaced. 		

CAUTION: Be careful not to grind into the base metal of the vessel.

- 1.0 Indicate on Attachment 1 which component stop or stops are being replaced.
- 2.0 Remove the old stop(s) by grinding.
- 3.0 Cut a piece(s) of 12 gauge 304 stainless steel from a certified sheet of stock.
- 4.0 Record the Certified Material Test Report (CMTR) number and Purchase Order Number of the original stock sheet.
- 5.0 Record the weld procedure number, revision, and date.
- 6.0 Grind the piece(s) of stainless steel to the required dimensions of the drawing. Bevel as required to aid in welding and fit-up.
- 7.0 Record the weld filler CMTR Number.

NOTE: The OCV lock ring stop on Unit 129 is the fifth lug clockwise from the OCV seal test port.

- 8.0 Tack the piece(s) of stainless steel in place per the current revision of drawing #2077-500SNP, Sheet 8 of 11, Section AY-AY, or Section AX-AX, or #707-SAR, Sheet 10 of 12, Section AZ-AZ, or Section BB-BB.
- 9.0 Verify the location and fit-up of the locking ring stop per drawing #2077-500SNP, Sheet 8 of 11, Section AY-AY or AX-AX, or #707-SAR, Sheet 10 of 12, Section AZ-AZ, or Section BB-BB.
- 10.0 Complete the weld(s) on the locking ring stop per drawing #2077-500SNP, Sheet 8 of 11, Section AY-AY or AX-AX, or #707-SAR, Sheet 10 of 12, Section AZ-AZ, or Section BB-BB.
- 11.0 Perform a visual inspection of the weld(s) in accordance with American Welding Society (AWS) Procedure D1.1.
- 12.0 Perform a liquid penetrant inspection of the weld(s) to ASME Code, Section III, Division 1, Subsection NB, Article NB-5000, and Section 5, Article 6.
- 13.0 Attach a copy of the inspection report(s) and CMTR(s) to the traveler or data sheet.
- 14.0 Verify the stop(s) was properly installed by: (1) installing the lid, (2) rotating the lid to the full open and full closed positions, and (3) removing the lid.
 - The lid should not bind on the new stop during lifting or lowering.
 - The lid open and closed marks should line up when the locking ring is against the locking ring stop.

Verification Requirements:

- 1.0 Work performed is described on Maintenance Record.
- 2.0 Work instruction is listed on Maintenance Record.
- 3.0 Data sheet (Work Instruction CH.16, Attachment 1) or traveler is attached to Maintenance Record.

ATTACHMENT 1 - DATA SHEET

Packaging SERIAL #: _____ Date: _____ Job. No.: _____		
STEP	OPERATION	SIGNOFF Operator / Date
1.	Check appropriate block <input type="checkbox"/> ICV Locking Ring Stop <input type="checkbox"/> OCV Locking Ring Stop	
2.	Remove old stop	
3.	Cut new stop	
4.	Record : CMTR # _____ PO # _____	
5.	Record weld procedure number, rev, and date _____/_____/_____	
6.	Grind new stop	
7.	Record filler CMTR # _____	
8.	Tack stop in place	
9.	Verify stop location and fit	QC
10.	Complete weld per dwg. 2077-500SNP, Sheet 8 of 11, Section AY-AY and/or Section AX-AX, or Dwg. #707-SAR, Sheet 10 of 12, Section AZ-AZ, or Section BB-BB.	
11.	Perform visual inspection	QC
12.	Perform liquid penetrant inspection	QC
13.	Attach inspection report(s), CMTR(s)	QC
14.	Perform retest	